

Work Order ID 71005

Tuesday, June 21, 2011 9:00:06 AM



Page 1

Item ID: D2804-042

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 6/20/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-06-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2804

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Press D2805-2 into arm as per Dwg D2804

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

120

0.00



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Powdercoat

Memo

0.00

Powder Coating

START TIME:

8:30am

OVEN TEMPERATURE:

9:00am FINISH TIME:

320°

EB 11/08/09 (3)

5 closlog

(43)

002

x3 d 11/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

3X Ø M-14/08/10

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Press Fit D2809 as per Dwg D2804

EP 11/08/10 (3)

150

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 □2-Assemble as per Dwg D2804.

EP 11/08/10 (3)

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Work Order ID 71005

Tuesday, June 21, 2011 9:00:06 AM



Page 3

Item ID: D2804-042	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Bracket Assembly				
Start Date: 6/20/2011	Start Qty: 3.00		Cust Item ID:	
Required Date: 6/23/2011	Req'd Qty: 3.00		Customer:	
Reference:				

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<u>5</u> <u>W08/10</u> <u>42</u>
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>Sylvia</u> Memo	0.00 0.00							<u>Pull 10</u> <u>(3)</u>
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>K11/08/11</u>

W11-08-11
(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 9:00:12 AM

Page 1

Work Order ID: 71005

Parent Item: D2804-042

Parent Item Name: Bracket Assembly



Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3 KJ/JLM
IPP Rev:G As per Rev C 06-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2804-2 		Manufactured	No			100	Each	3.0000	1	3			
Bracket													

Location Loc Qty Loc Code

ST149 3
46613 3

D2805-2 		Manufactured	No			100	Each	2.0000	1	3			
Stop													

Location Loc Qty Loc Code

GA 2
64454 2

NAS1515H3 		Purchased	No			100	Each	96.0000	4	12			
Washer													

Location Loc Qty Loc Code

ST277 96
116373 6
117460 90

AN3C16A 		Purchased	No			150	Each	29.0000	2	6			
Bolt													

Location Loc Qty Loc Code

ST352 29
115835 29

Handwritten notes and signatures:
 3 6/21/08/09
 3 6/21/08/09
 B 71559 (3x)
 12 6/21/08/10
 6 6/21/08/10
 4 6/21/08/10
 M118078 (12x)
 M118191 (2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Tuesday, June 21, 2011 9:00:13 AM

Page 2

Work Order ID: 71005

Parent Item: D2804-042

Parent Item Name: Bracket Assembly



Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 3.00

Required Qty: 3.00

D2809

Manufactured No

150

Each

22.0000

1

3



Bushing



EP 5/11/08/10

Location

Loc Qty

Loc Code

ST

10

70805

10

ST023

12

34035

12

3

MS21043-3

Purchased No

150

Each

1,215.000

2

6



Nut



EP 5/11/08/10

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1143

112314

143

118077

1000

6

Tuesday, June 21, 2011 9:00:13 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

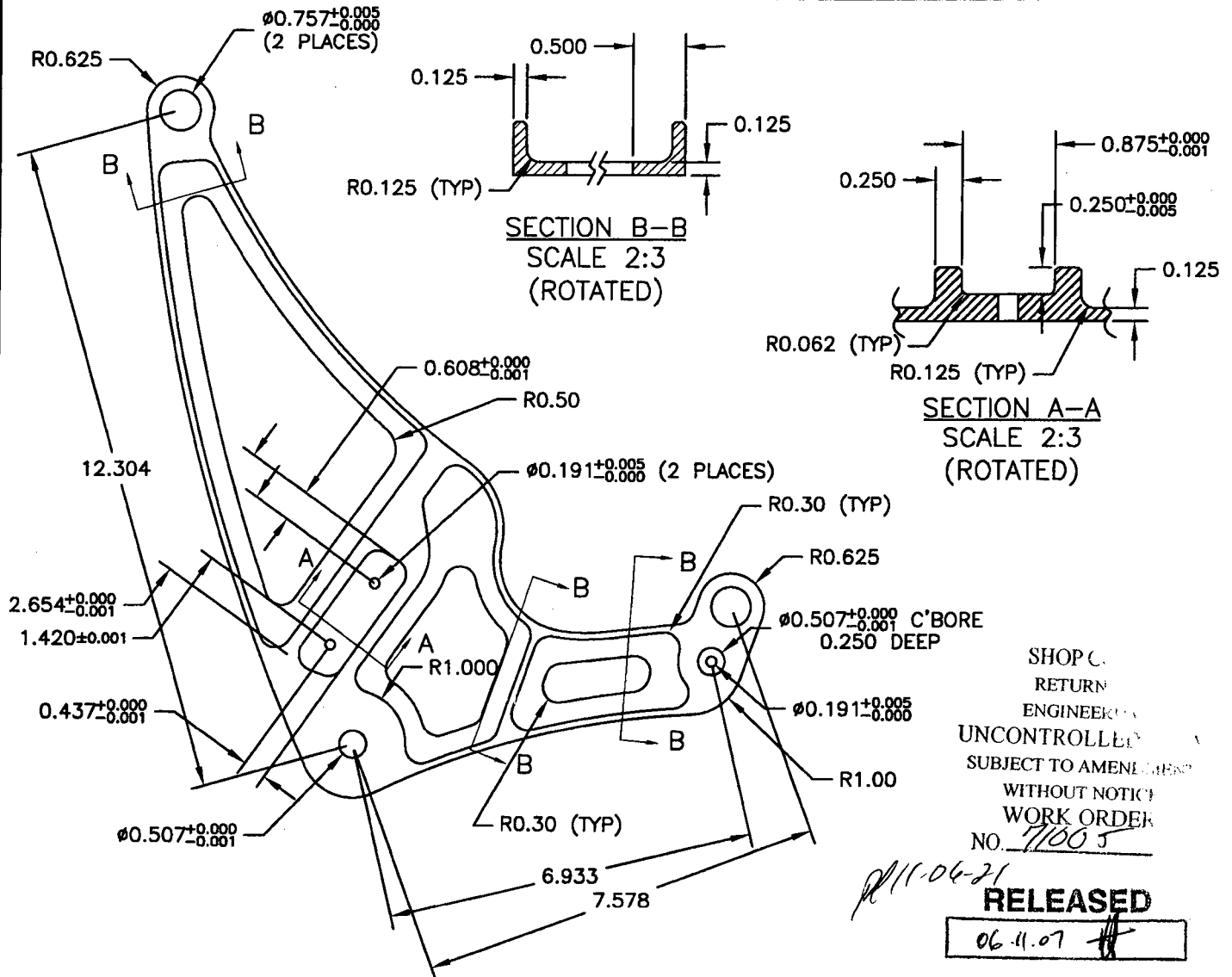
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16	TITLE STA 155 BRACKET		SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	



D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

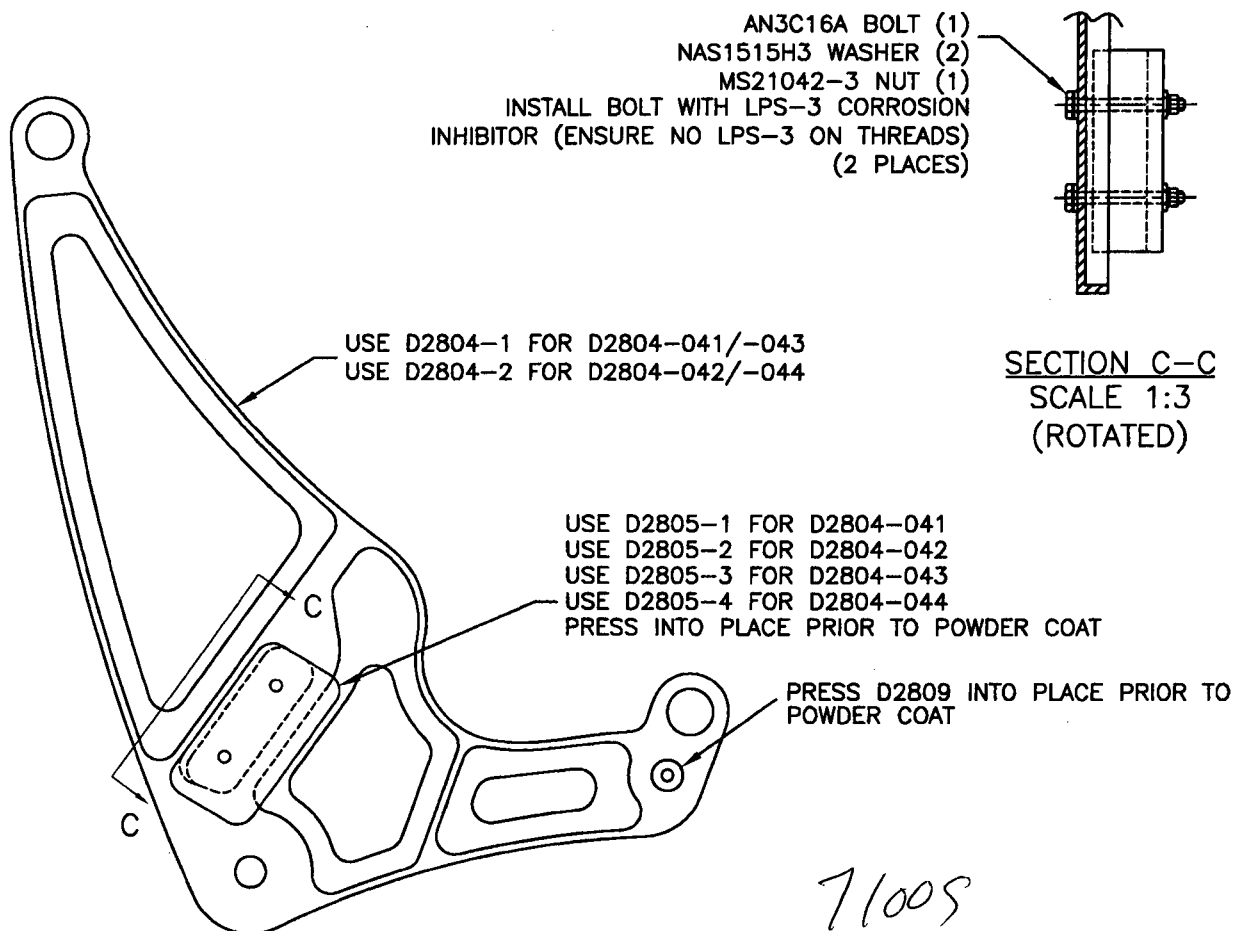
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• **NOTE:** Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3

**RELEASED**06.11.07 *[Signature]***D2804-041/-043 BRACKET ASS'Y (SHOWN)****D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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